

Work Order ID 108061***108061***

Page 1

October-07-13 9:10:18 AM

Item ID:	D2137	Accept	*N900040100*	Setup	Start	*NS1*		
Revision ID:					Stop	*NS2*		
Item Name:	Decal(No Step)							
Start Date:	10/07/13	Start Qty:	20.00	*20*	Cust Item ID:			
Required Date:	10/07/13	Req'd Qty:	20.00	*20*	Customer:			
Reference:								
Approvals:	Process Plan: <u>MLJ</u>	Date:	<u>13-10-08</u>	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:		SPC (Y/N):	Date:	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
100		0.00							
100 Purchasing		0.00							
	Memo								
	Issue P/O <u>21646</u>								
	Make per Dwg 2137								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110 Packaging		0.00							
	Memo								
120	QC6- Inspect dimensions to drawing	0.00	DAS 27 9-89						
120 QC		0.00	<u>B 10 B</u>						
	Memo								
Quality Control									

13/10/08 2013/10/16 2020

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS									
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>								
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>								
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>								
			Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>									
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector				
Doc/Data															
Equip/Tooling															
Operator															
Material															
Setup															
Other															
Process															
Supplier															
Training															
Unapproved															
FAULT CATEGORY															
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio				<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled	
														<input type="checkbox"/> Other	

Work Order ID 108061

108061

Page 2

October-07-13 9:10:18 AM

Item ID: D2137

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Decal(No Step)

Start Date: 10/07/13 Start Qty: 20.00

20

Cust Item ID:

Required Date: 10/07/13 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: GA

0.00

130

Packaging

Packaging

20X
DAS
28
9.89

13-10-16

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Quality Control

Memo

0.00

13-10-17

MB-10-17

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other			
Root Cause		Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence Wave/Twist in Tube				General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish Folio		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset Out of Calibration Out of Sequence Outside Dimensions		Ovalized Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Positioned Wrong Power Loss/Surge		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other	

Picklist Print

October-07-13 9:10:17 AM

Page 1

Work Order ID: 108061

Parent Item: D2137

Parent Item Name: Decal(No Step)

Start Date: 10/07/13

Required Date: 10/07/13

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: B02.02.01Added step 3 and Inspection level 21 SM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2137P Decal - No Step		Purchased	No			100	Each	0.0000	1	20		13/14/26 (2)	

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

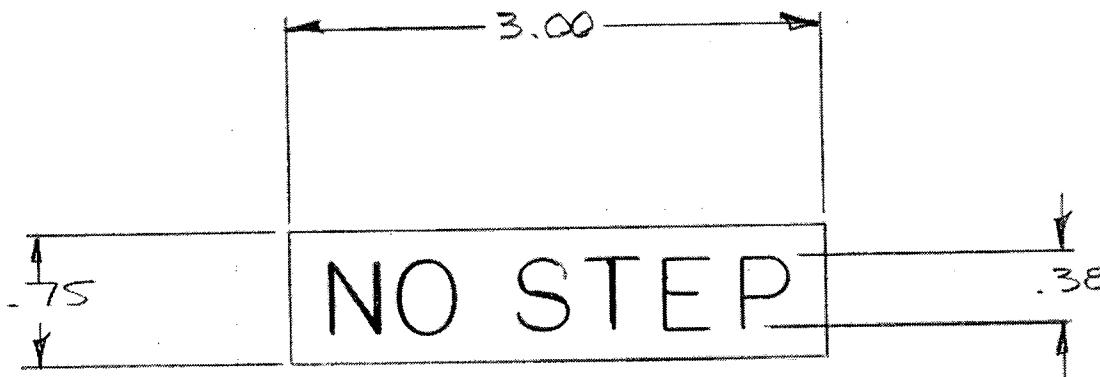
QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS				
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>			
	Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>				

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear		General									
Bending	<input type="checkbox"/>	Bend	<input type="checkbox"/>	Grain	<input type="checkbox"/>	Ovalized	<input type="checkbox"/>	Pressure/Forced			
Centre Not Concentric to O/S	<input type="checkbox"/>	BOM/Route	<input type="checkbox"/>	Hardware	<input type="checkbox"/>	Over/Under tolerance	<input type="checkbox"/>	Temperature/Cure			
Cracks	<input type="checkbox"/>	Broken/Damaged	<input type="checkbox"/>	Inspection Incomplete	<input type="checkbox"/>	Part Incorrect	<input type="checkbox"/>	Weld			
Crushed/Crimped	<input type="checkbox"/>	Burrs	<input type="checkbox"/>	Instructions Incomplete/Unclear	<input type="checkbox"/>	Part Lost/Missing	<input type="checkbox"/>	Wrong Stock Pulled			
Cuffs	<input type="checkbox"/>	Contamination	<input type="checkbox"/>	Maintenance	<input type="checkbox"/>	Part Moved	<input type="checkbox"/>				
Heat Treat	<input type="checkbox"/>	Countersink	<input type="checkbox"/>	Mislabeled	<input type="checkbox"/>	Positioned Wrong	<input type="checkbox"/>				
Inspection Strip in Tube	<input type="checkbox"/>	Cut Too Short	<input type="checkbox"/>	Misread	<input type="checkbox"/>	Power Loss/Surge	<input type="checkbox"/>				
Ripples in Bend	<input type="checkbox"/>	Drill Holes	<input type="checkbox"/>	Offset	<input type="checkbox"/>	Other	<input type="checkbox"/>				
Torque Waves in Extrusion	<input type="checkbox"/>	Drawing	<input type="checkbox"/>	Out of Calibration	<input type="checkbox"/>		<input type="checkbox"/>				
Turning Sequence	<input type="checkbox"/>	Finish	<input type="checkbox"/>	Out of Sequence	<input type="checkbox"/>		<input type="checkbox"/>				
Wave/Twist in Tube	<input type="checkbox"/>	Folio	<input type="checkbox"/>	Outside Dimensions	<input type="checkbox"/>		<input type="checkbox"/>				



108061 ML5
13-10-08

ALTERNATE MATERIAL:

3M 7 MIL MASKING FILM #8522CP

SILVER OR WHITE ON BLACK

~~off~~ 00.09.05
CP 00.09.05

MATERIAL: 3M POLYESTER

NATURAL (SILVER or
WHITE) ON BLACK
.003 THICK



LE 12 D

REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 523		PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR
DRAWN					CONTRACT NO.				
APPROVED					DRAWN	DATE			
DESCRIPTION	REQUIREMENTS - UNLESS OTHERWISE SPECIFIED	GENERAL	BASIC CODE	DIA. DASH NO. RIVHEAD NEAR SIDE F-HEAD FAR SIDE					
OF CHANGE		UNITS	D-CRIMP D-CRIMP NO. OF SHEETS C-COUNTERFORM	LENGTH DASH NO. WH-SMOOTH	DESIGN	92			
	1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS .001 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER INCH - 6. 7747 5. HOLES PER INCH 10087 6. SYMMETRY ABOUT ALL M/C CENTRE LINES .005	1. TOLERANCES - .005 ± .000 .000 ± .010 2. ANGLES .90° 3. PARALLELISM .0075 4. PERPENDICULARITY .005 MAX 5. SYMMETRY ABOUT ALL M/C CENTRE LINES .005	BASIC CODES B-P-M2047040 B-B-M2042840		STRESS				
	REPORT ALL DISCREPANCIES - DO NOT SCALE				CHECKED				
					CODE	DMG NO.			
						D 2137			
					SCALE	1:1	SH1	1 OF 1	REV.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO21646**

Purchase Order Date 10/9/2013

PO Print Date 10/9/2013

Page Number 1 of 2

Order From :
STUDIO DE LETTRAGE 2001
210 MAIN WEST
HAWKESBURY, ON K6A 2H6
CA

VC-STU001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

RECEIVED
10/13/10

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	613 632 5449	Customer POID	
Ship To Contact		Customer Tax #	10127-2607
Ship To Phone		Terms	Net 30
Ship Via:	Yours ppd	Currency	CAD
Ship Acct:		FOB	Destination-Collect

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	Line Comments		Promise Date				
1	D2137P	Decal - No Step	10/15/2013 Yes 10/15/2013		20.00 Each	\$3.75	\$75.00
	AS PER DWG D2137 REV. JAN 29 1992					Line Total:	\$75.00
2	D4166-1P	Placard, Max Load	10/15/2013 Yes 10/15/2013		10.00 Each	\$7.50	\$75.00
	AS PER DWG D4166 REV. B B108270					Line Total:	\$75.00
3	D3671-1P	Placard	10/15/2013 Yes 10/15/2013		24.00 Each	\$3.25	\$78.00
	AS PER DWG D3671 REV. A B108271					Line Total:	\$78.00

Note:

Studio de Lettrage

210 Main Street W
Hawkesbury, Ontario K6A 2H6

INVOICE

Invoice No.: 21031
Date: 10/15/2013
Ship Date:
Page: 1
Re: Order No. WO11044

Sold to:

Dart Aerospace Ltd
1270 Aberdeen
Hawkesbury, Ontario K6A 1K7

Ship to:

Dart Aerospace Ltd
Hawkesbury, Ontario

Business No.: 82500 7651 RT0001

Item No.	Unit	Quantity	Description	Tax	Unit Price	Amount
		20	D2137P Decal no step stickers printing	H	1.2500	25.00
		1	set up	H	50.0000	50.00
		10	D4166-1P placard max load printing	H	2.5000	25.00
		1	set up	H	50.0000	50.00
		24	D3671-1P placard printing	H	1.0417	25.00
		1	set up	H	50.0000	50.00
			H - HST 13% HST			29.25
Studio de Lettrage HST: #825007651RT0001						
Shipped By:	Tracking Number:					
Comment:					Total Amount	254.25
Sold By:						

****Certificate of Conformity****

Customer:

Studio Lettrage

<u>Purchase Order #:</u>	<u>Packing Slip #:</u>	<u>Part #:</u>	<u>Serial #:</u>
	11044		

<u>Description:</u>	<u>Quantity:</u>
Stickers	54 STICKERS

Certification:

We hereby certify that:

1. The above the listed items were manufactured, repaired and/or inspected in accordance with applicable drawings and/or specifications;
2. All work was accomplished in accordance with the Dart Aerospace Purchase Order;
3. Results of all inspections, chemical or physical tests, as well as other evidence, which shows the acceptability of raw materials, parts and/or assembly components are on file and available for inspection at any time.

Authority:

ALEXA

<u>APPROVAL:</u>	Alexa Pleury
------------------	--------------

<u>Signature:</u>	Alexa Pleury
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<u>Title:</u>	Project Coordinator
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<u>DATE:</u>	15 October 2013
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15 October 2013

PRODUCT DATA SHEET



Avery® IPM™ 2031

issued: 01/04/2005

Introduction

Avery® IPM™ 2031 is a high quality pressure-sensitive vinyl film, designed for use on wide format inkjet printers. Avery® IPM™ 2031 has excellent printing properties, allowing crisp print quality with bright and vibrant colours. Avery® IPM™ 2031 offers rapid ink drying and a water-resistant material. It combines good adhesion during its life and easy removal afterwards.

Description

Facefilm: 80-micron premium white calendered, topcoated vinyl.

Adhesive: removable, acrylic based

Backing paper: one side coated kraft paper, 140 g/m²

Features

- Excellent printability
- Vibrant and bright colours
- Crisp print quality
- Spray water resistant with specific pigmented inks
- Good adhesion, excellent removability
- Warranty on outdoor durability

Recommendations for use

A wide variety of full-colour graphics for indoor - and **short/medium term outdoor** applications such as posters, murals, displays, exhibition stands, vehicle graphics etc. Avery® IPM™ 2031 is suitable for application to a wide variety of substrates and will remove cleanly for up to 1 year after application.

IPM media should be handled with care as any surface contamination may affect the print quality. Media should be processed in an environment of 15-25°C and 30-70% relative humidity. After drying, the finished prints should be wrapped in polyethylene film and despatched flat or rolled with the printed side facing outwards. To protect prints against water, UV/light and abrasion, overlamination with a clear film is recommended. For specific details of Avery® DOL combinations, refer to ["Technical Bulletin 5.3. Recommended combinations of Avery® Overlaminate and Avery® Digital Print Media"](#)

Always test your combination of Avery® IPM™ medium, inkjet printer and inks prior to commercial use.

Compatibility

Avery® IPM™ 2031 is compatible with a broad selection of inkjet printers, when printing with pigmented, water based inks. For specific details refer to ["Technical Bulletin 5.6 Avery Dennison Inkjet Print Media - Printer compatibility"](#).

Durability:

Avery® IPM™ 2031 is warranted for outdoor use in conjunction with pigmented outdoor inks from HP, Encad and Colorsprint. The warranted period varies from type of application and type of overlaminates from 18 months up to 5 years. For full details, see our Avery® IPM™ Outdoor warranty.



www.averygraphics.com

Graphics Division
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2394 ZG Hazerswoude - The Netherlands
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Page 1 of 2